

split
8/30/1061u

24

Data: Thursday, 5/31/2007 7:21:03 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP RH (FOLDING)		
Job Number	: 32714					
Estimate Number	: 12568					
P.O. Number	: N/A			Part Number	: D412630034	
This Issue	: 5/31/2007	S.O. No.	: N/A	Drawing Number	: IIN D412-630 REV K	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: K	
Previous Run	: 29385			Material	: N/A	
Written By	:			Due Date	: 6/11/2007	
Checked & Approved By	:			Qty:	3	
Comment	: Est. Rev.A New Issue 06-11-08 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG002	(3) DC L KJ 07-05-31
2.0	D2012107	Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: → Qty Part Number Description Batch 1 D2012-107 Clevis B29883	(1) (2)
3.0	D2803042	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-042 Bracket Assembly RH B29392	
4.0	D2804042	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-042 Bracket Assembly RH B26252 7/14/08	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/11	18	split u/o			SB	07/06/11			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:21:04 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: HELI-ACCESS STEP RH (FOLDING)
Job Number: 32714			Part Number: D412630034
Job Number:			
Seq. #:	Machine Or Operation:		Description :
5.0	D2807		Support Prop 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Support Prop Pick: Qty Part Number Description Batch			<i>1528487</i>
6.0	D2813		Washer 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Washer Pick: Qty Part Number Description Batch			<i>1525923</i>
7.0	D3562042		STEP ASSEMBLY, RH 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch			<i>B255923 B 32720.</i>
8.0	D33951		Bushing 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bushing Pick: Qty Part Number Description Batch			<i>(4x) B27291, (4x) B25935 B24770.</i>
9.0	AN3C21A		BOLT 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) BOLT Pick: Qty Part Number Description Batch			<i>6 M19633, 7/6/14 SP</i>

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

(5)

Pick:

Qty Part Number Description

Batch

2 AN8C16 Bolt

M100695

(1)

M102736

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty Part Number Description

Batch

2 AN310C8 Nut

M100433

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number Description

Batch

2 MS24665-302 Cotter Pin (or AN380C3-4)

M169411

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

6 NAS1515H3 Washer

M19633X

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty Part Number Description

Batch

4 NAS1515H5L Washer

M103286, 76014 SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	M102067

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	M103691

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	M101390

7/6/450

18.0 SMALL FAB 1. SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M101472

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M17045

MF 07-06-18

②

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

m29393 ✓

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

b29394 ✓

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

b27287 ✓ ✓

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

b27290 ✓ ✓

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M102039 ✓ ✓

7/6/4 50

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M100273 ✓

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M101291 ✓

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M10171 ✓

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M100229 ✓

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M101428 7/6/4 SA

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	NAS1515H5	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

(3X)

(1)

(18) ✓

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

M100955 *

32.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M104537 ✓ ✓

33.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
3	MS21043-5	Nut

Batch

M101418 ✓ ✓ 7/6/459

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: A

PPP Rev: A

7/6/2007 22:00 2007/06/22 22:00

36.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



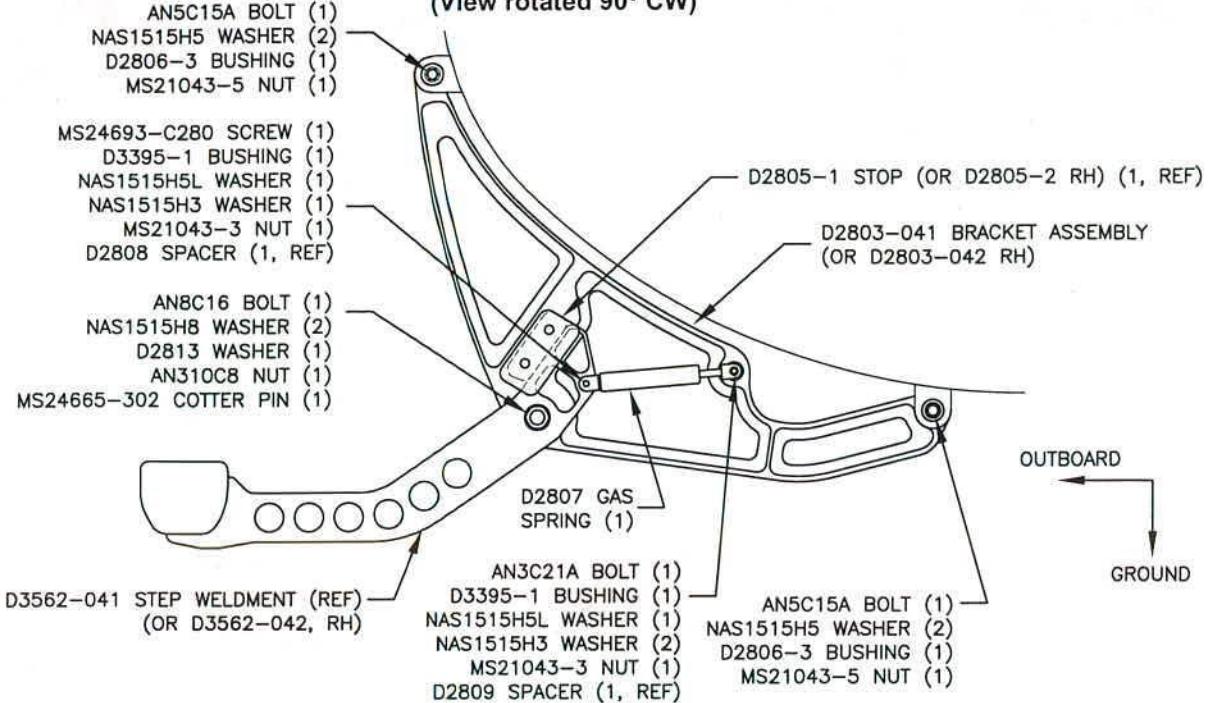
2007/06/25 2007/05/25

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**